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(54) **TOY PROJECTILE AND METHOD OF MAKING**
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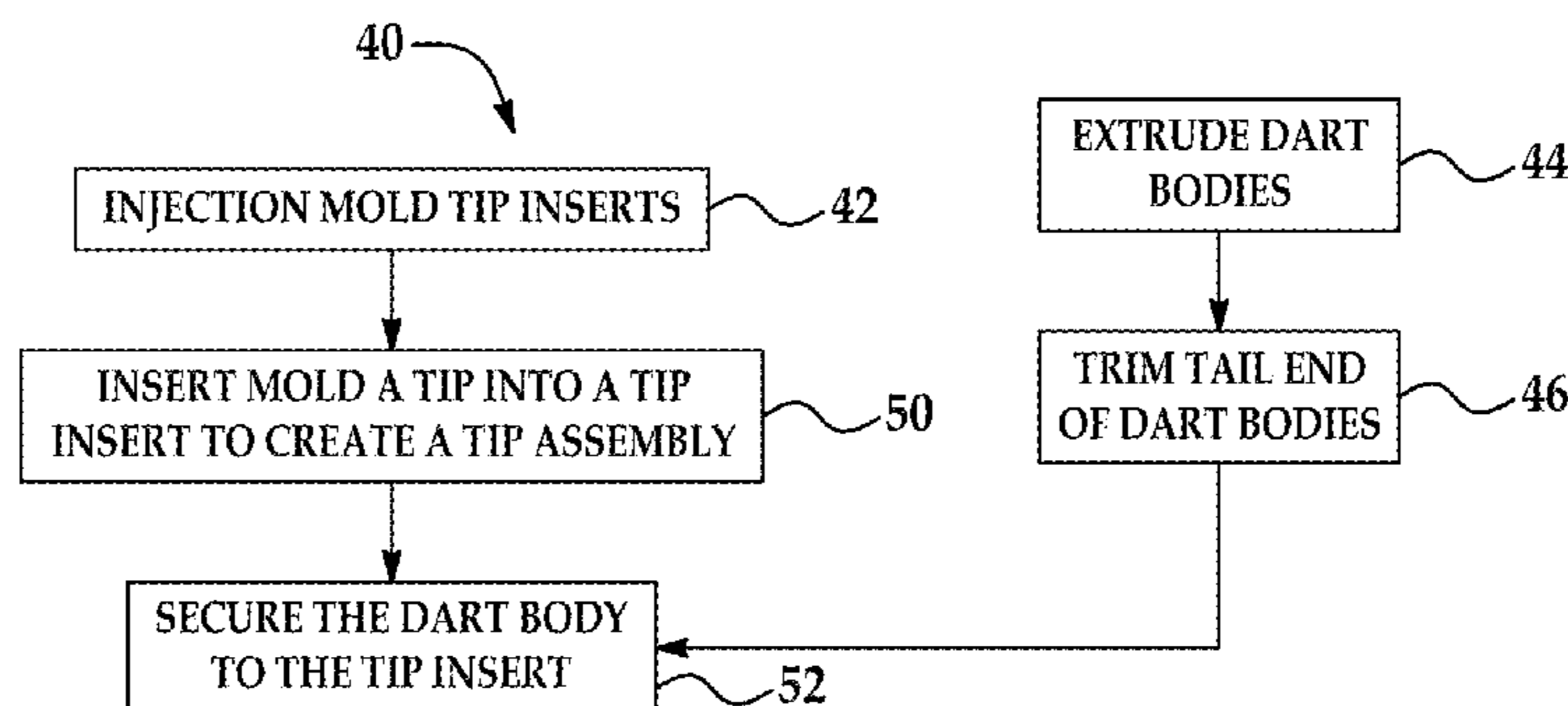
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(57) **ABSTRACT**
A toy projectile and method of making the toy projectile is provided herein. The toy projectile having: an elongated dart body secured to a tip assembly, the tip assembly comprising: a tip insert secured to a forward end of the elongated dart body and a tip secured to the tip insert, wherein the tip comprises a styrene ethylene butylene styrene copolymer (SEBS rubber) tip.

20 Claims, 7 Drawing Sheets



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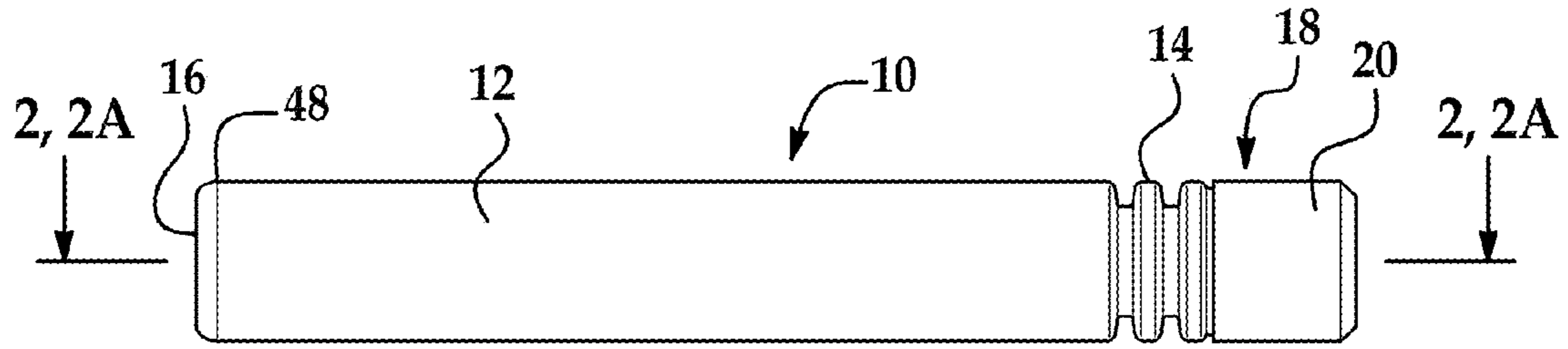


FIG. 1

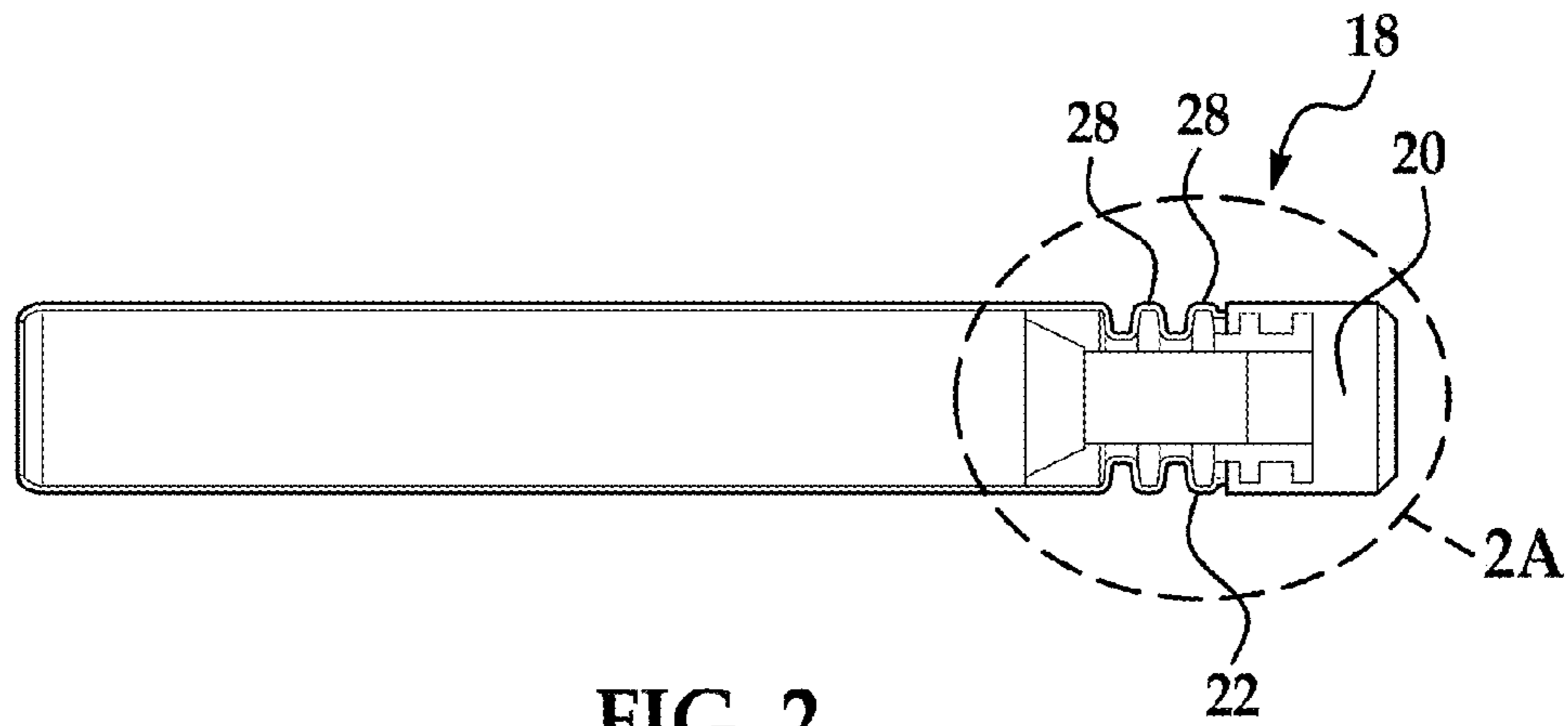


FIG. 2

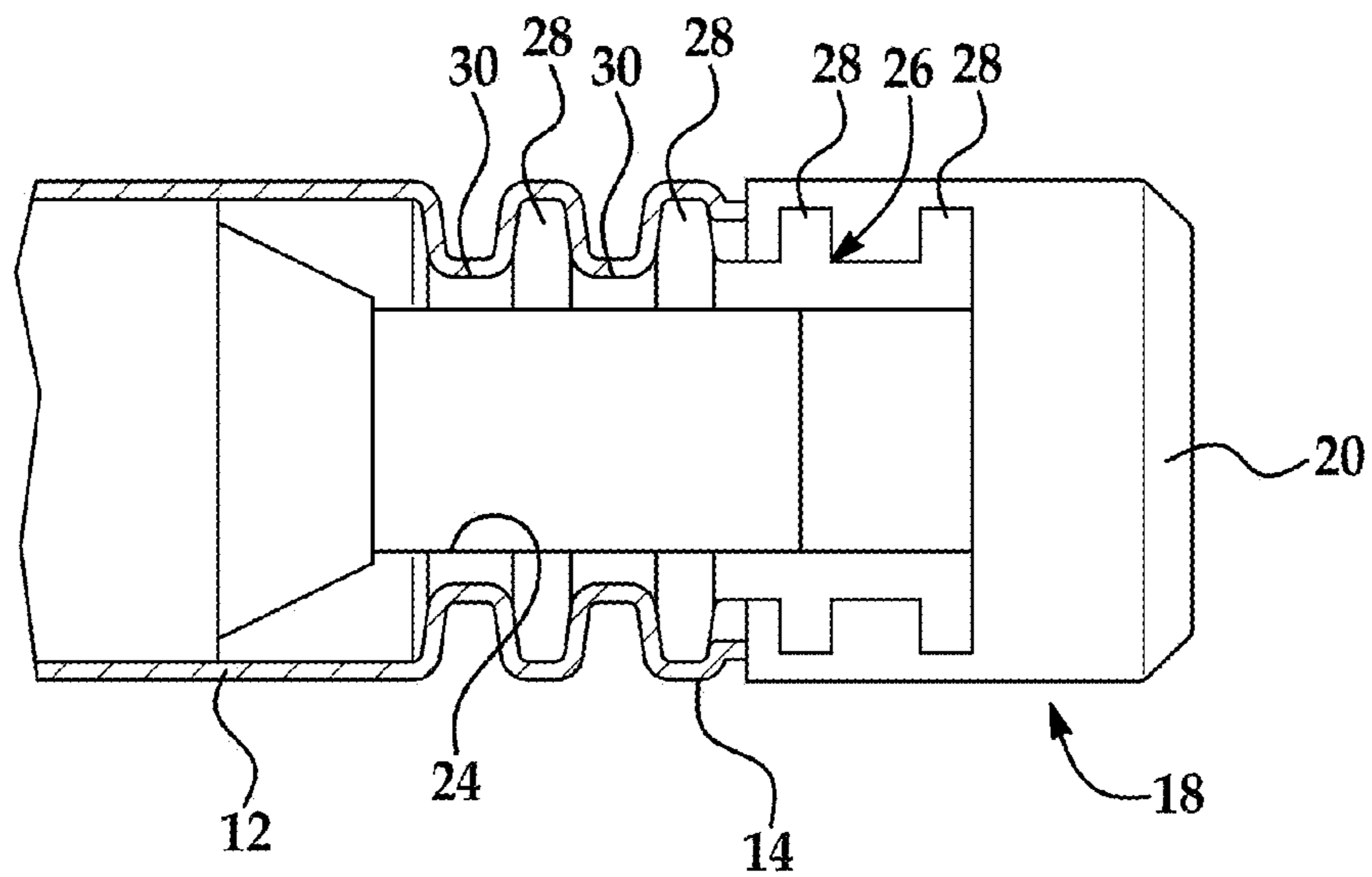


FIG. 2A

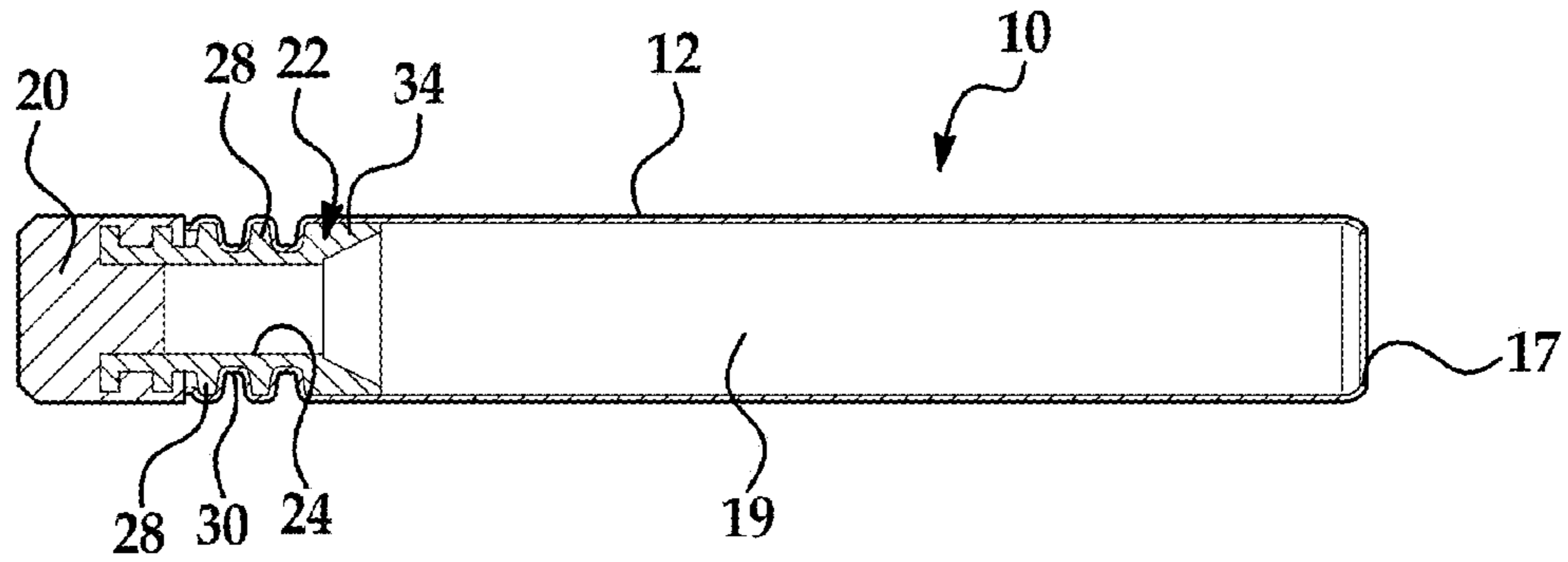


FIG. 2B

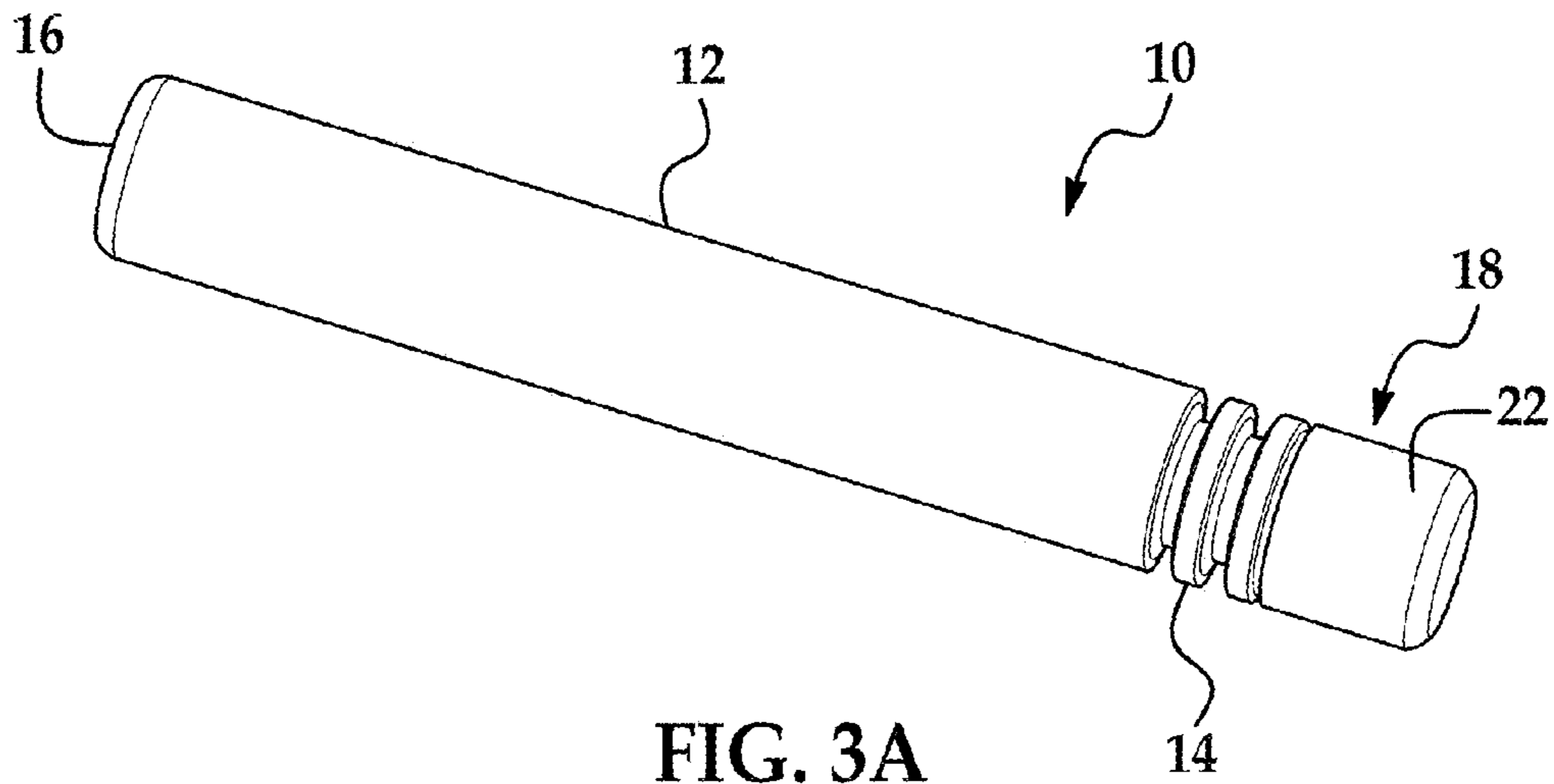


FIG. 3A

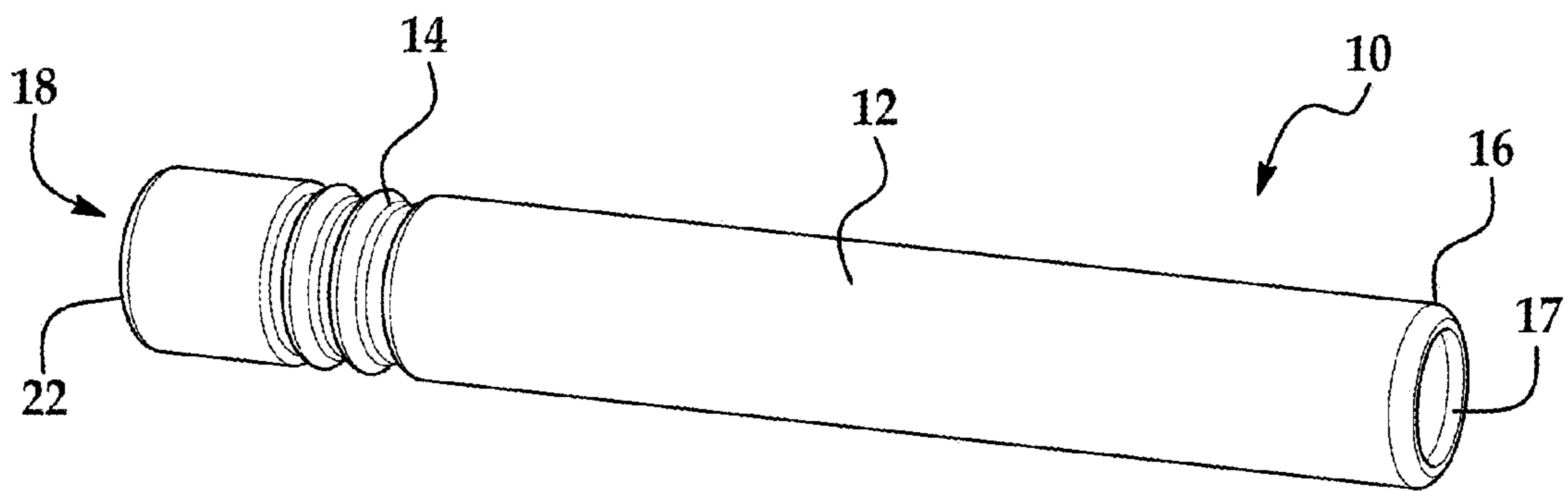


FIG. 3B

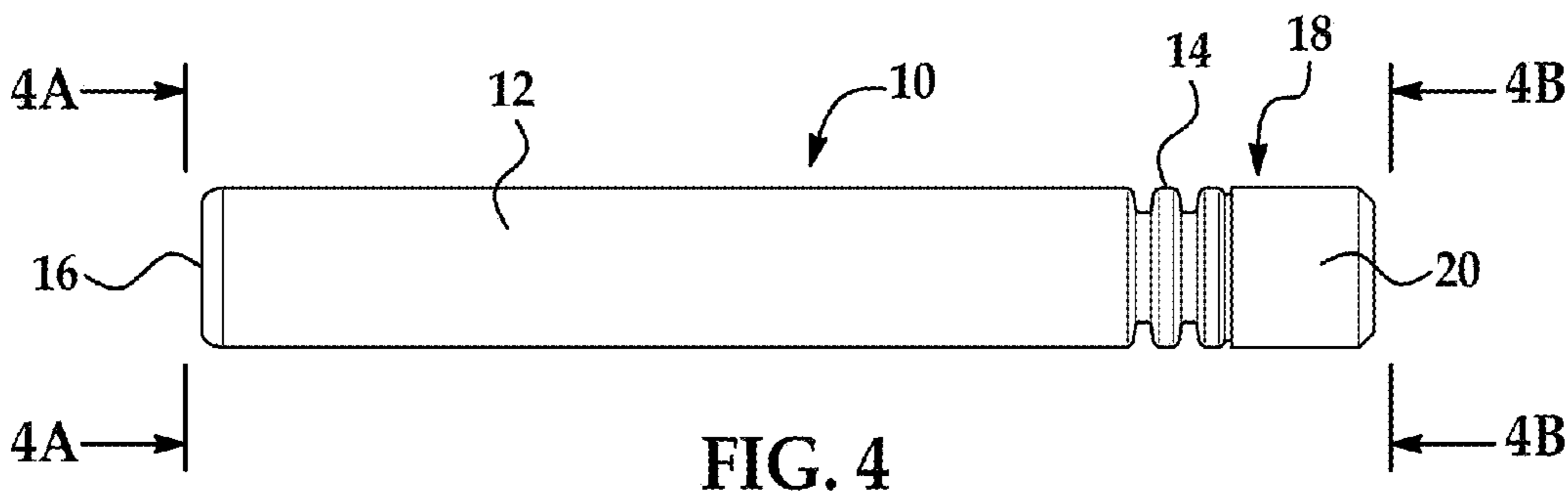


FIG. 4

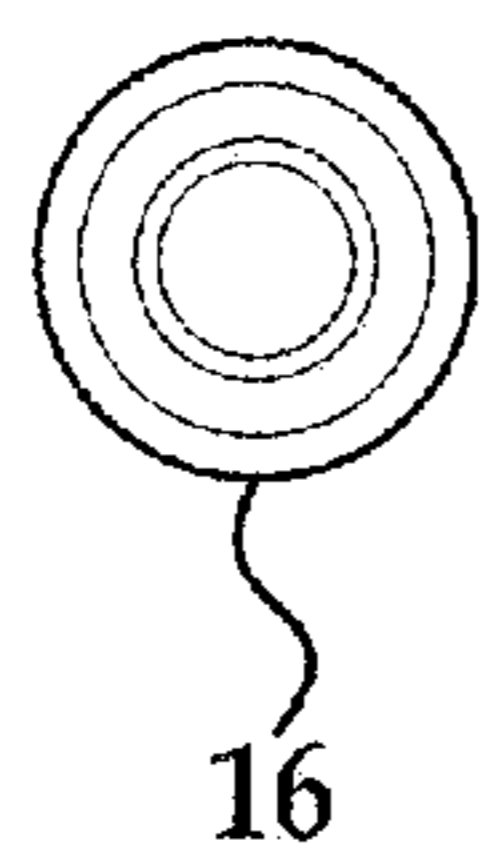


FIG. 4A

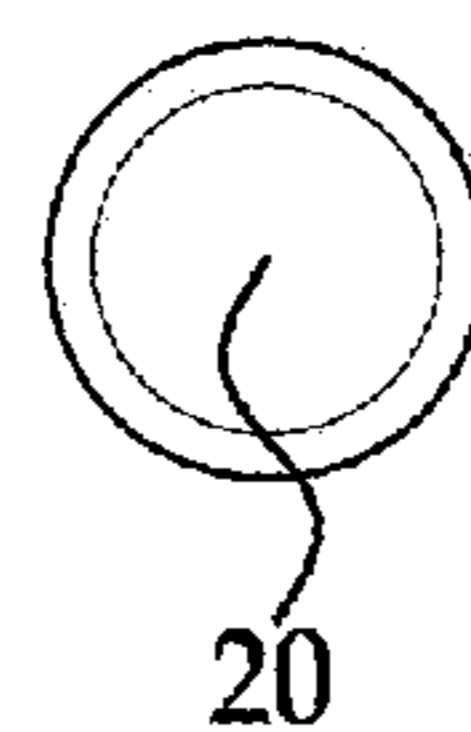


FIG. 4B

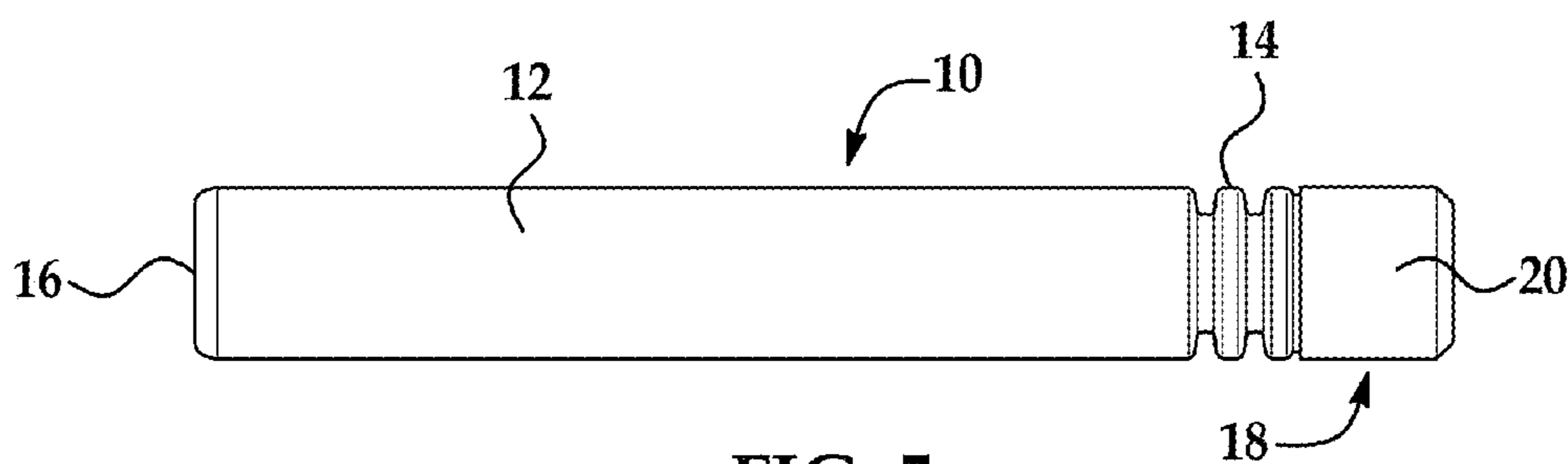


FIG. 5

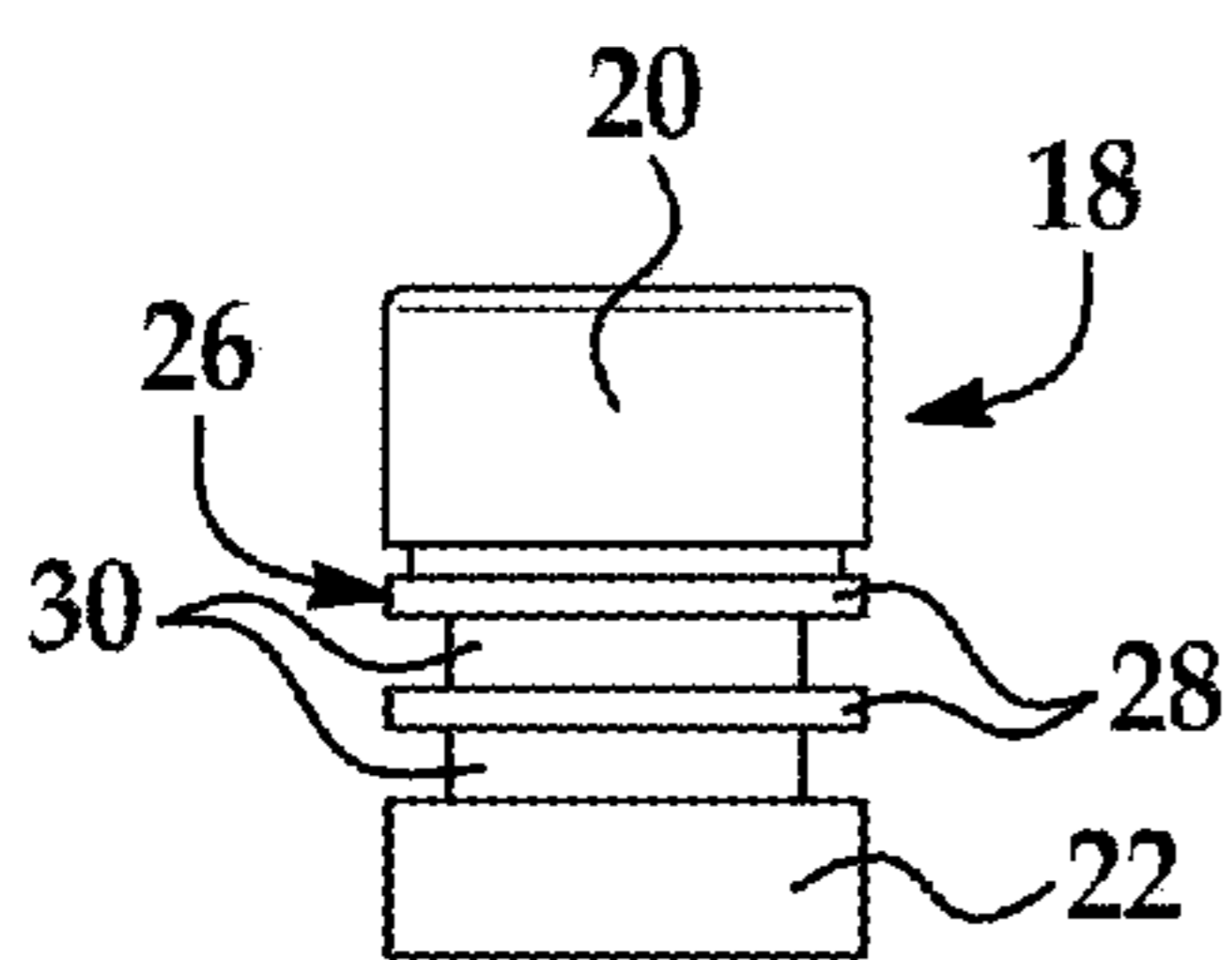


FIG. 6

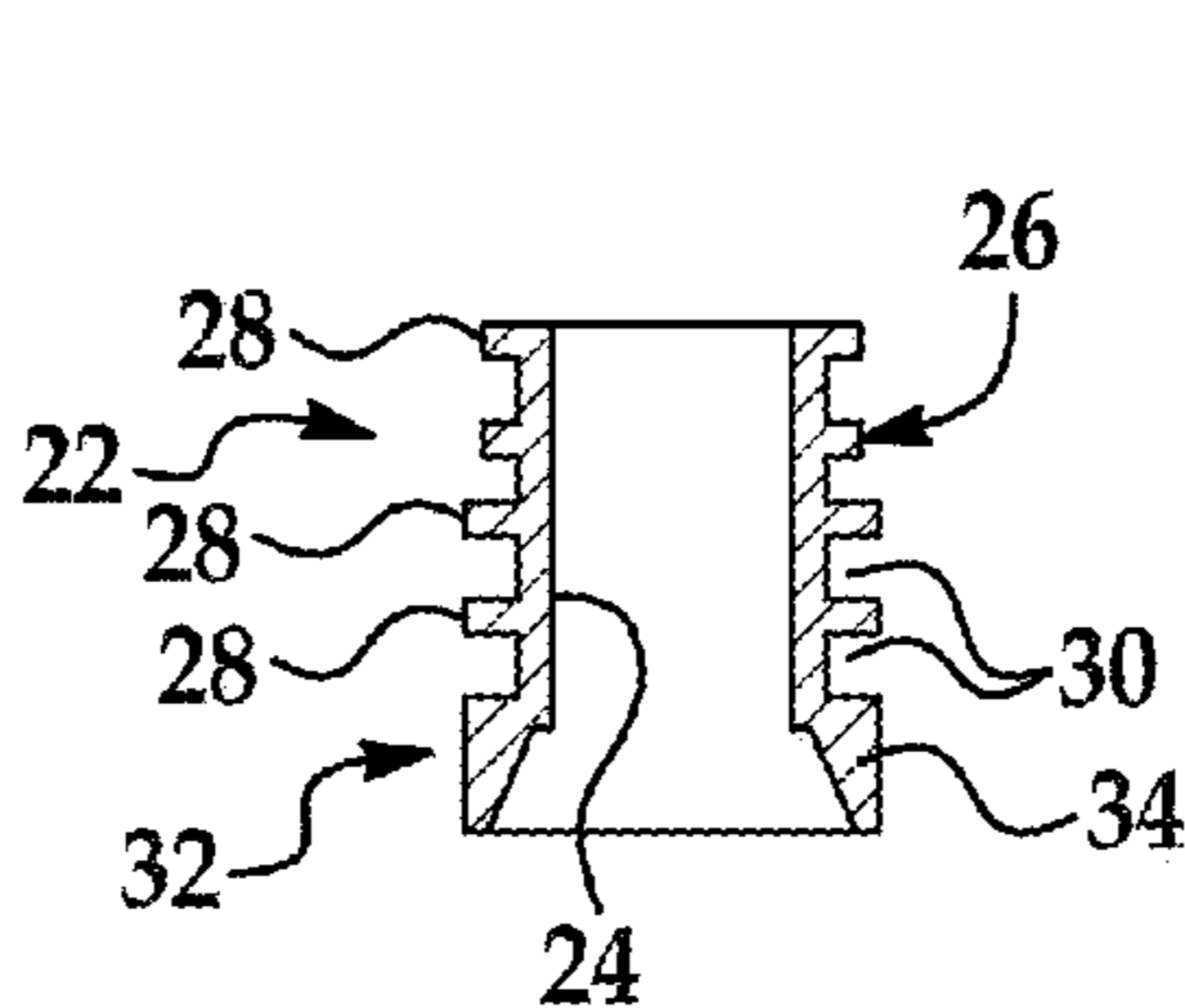


FIG. 7

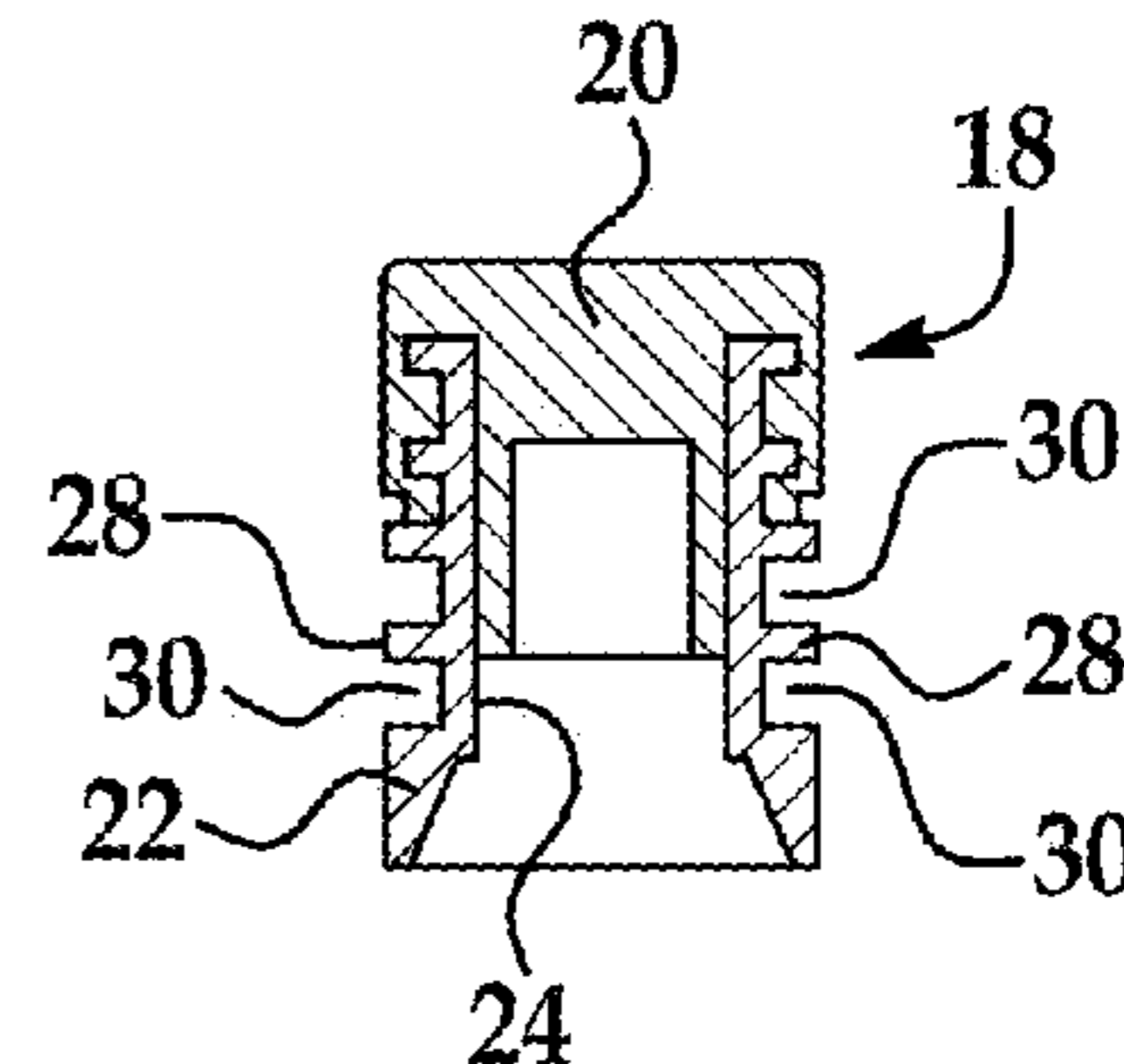


FIG. 8

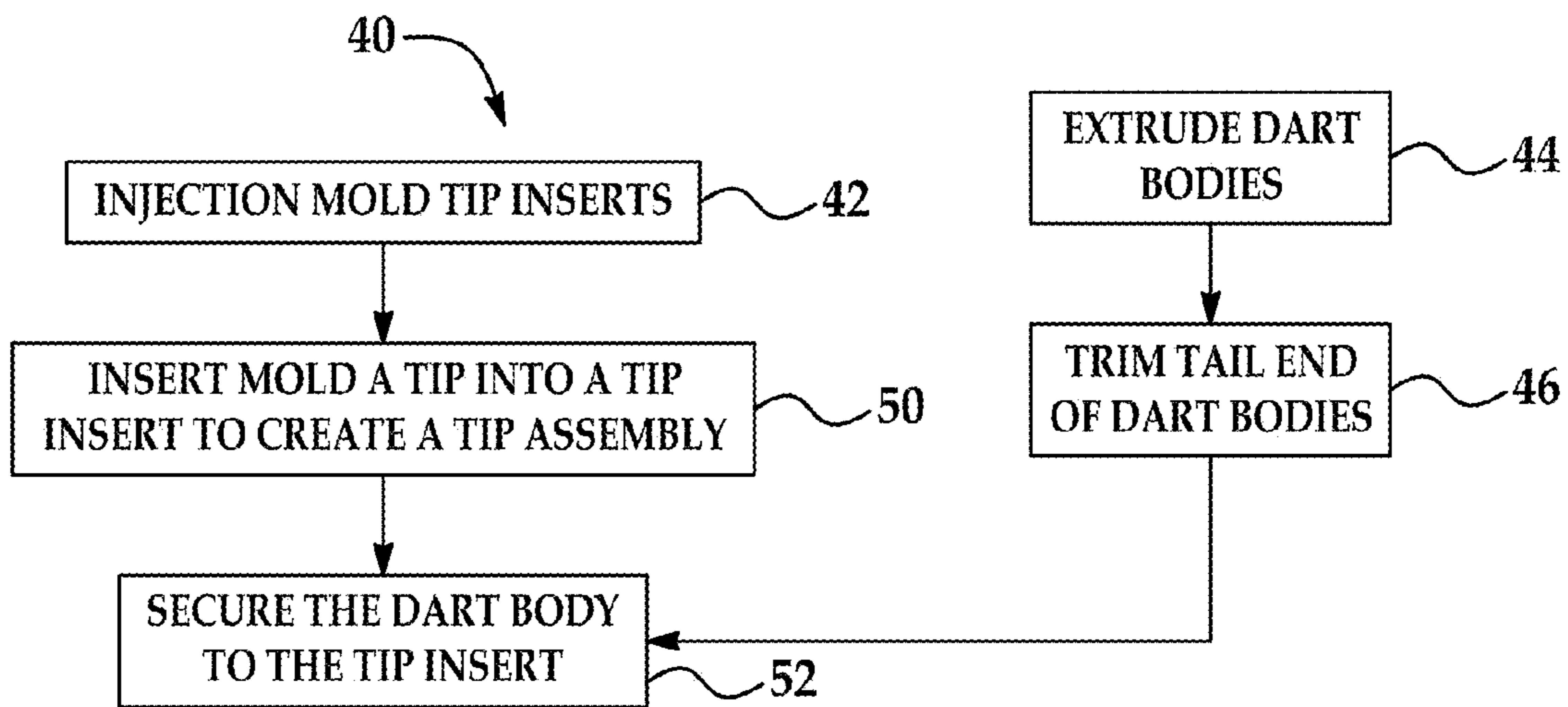


FIG. 9

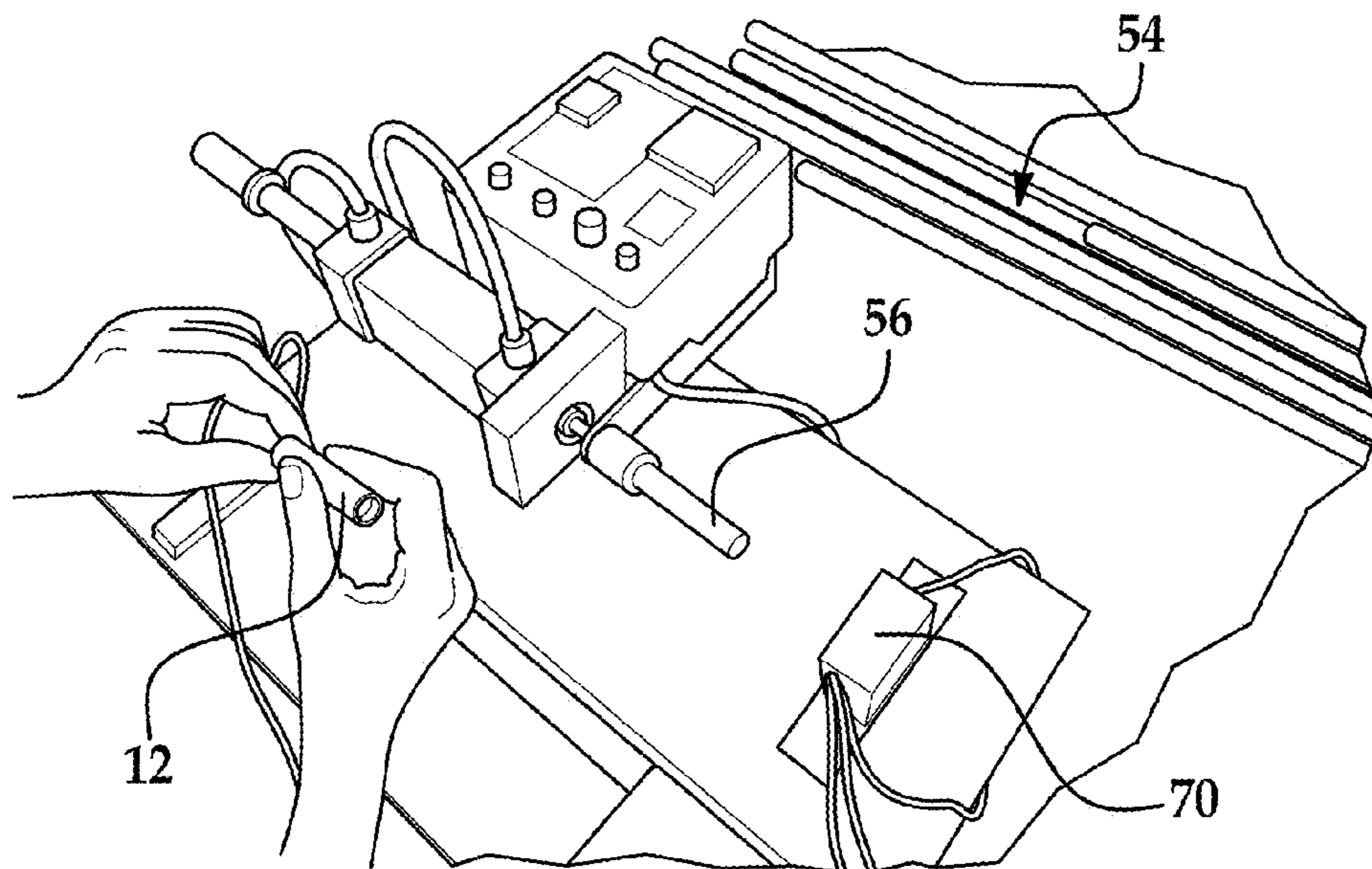


FIG. 10

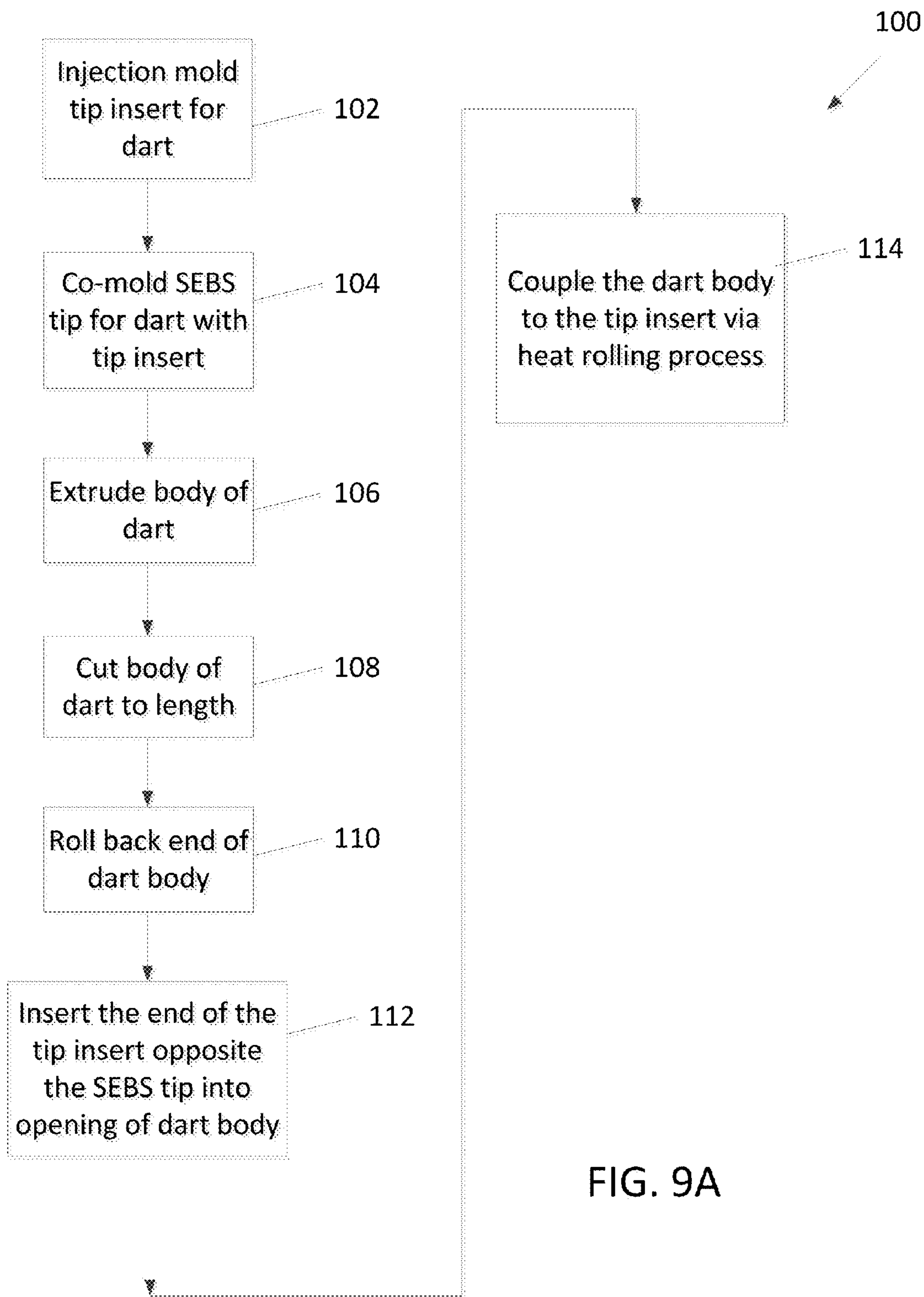


FIG. 9A

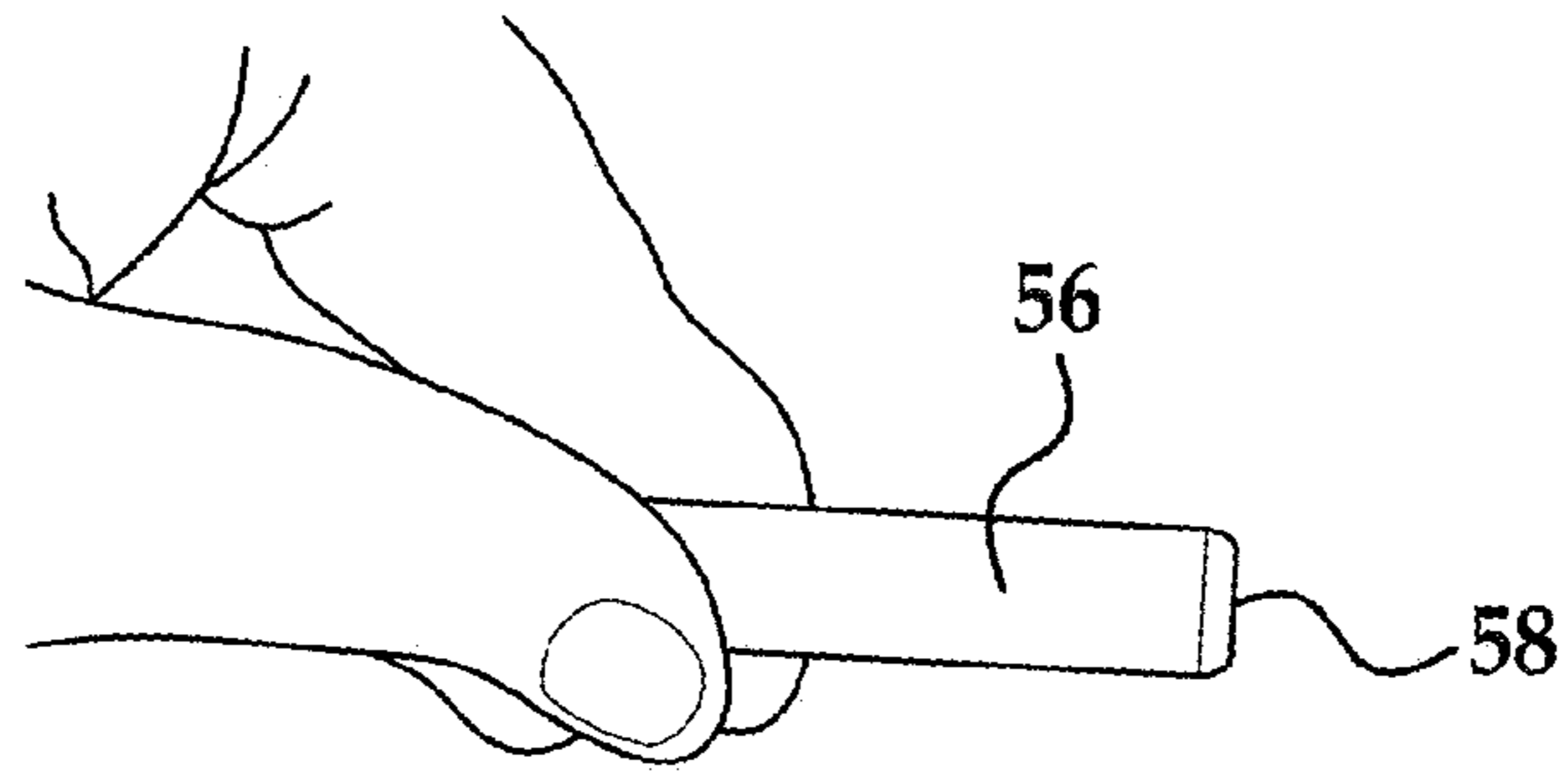


FIG. 11

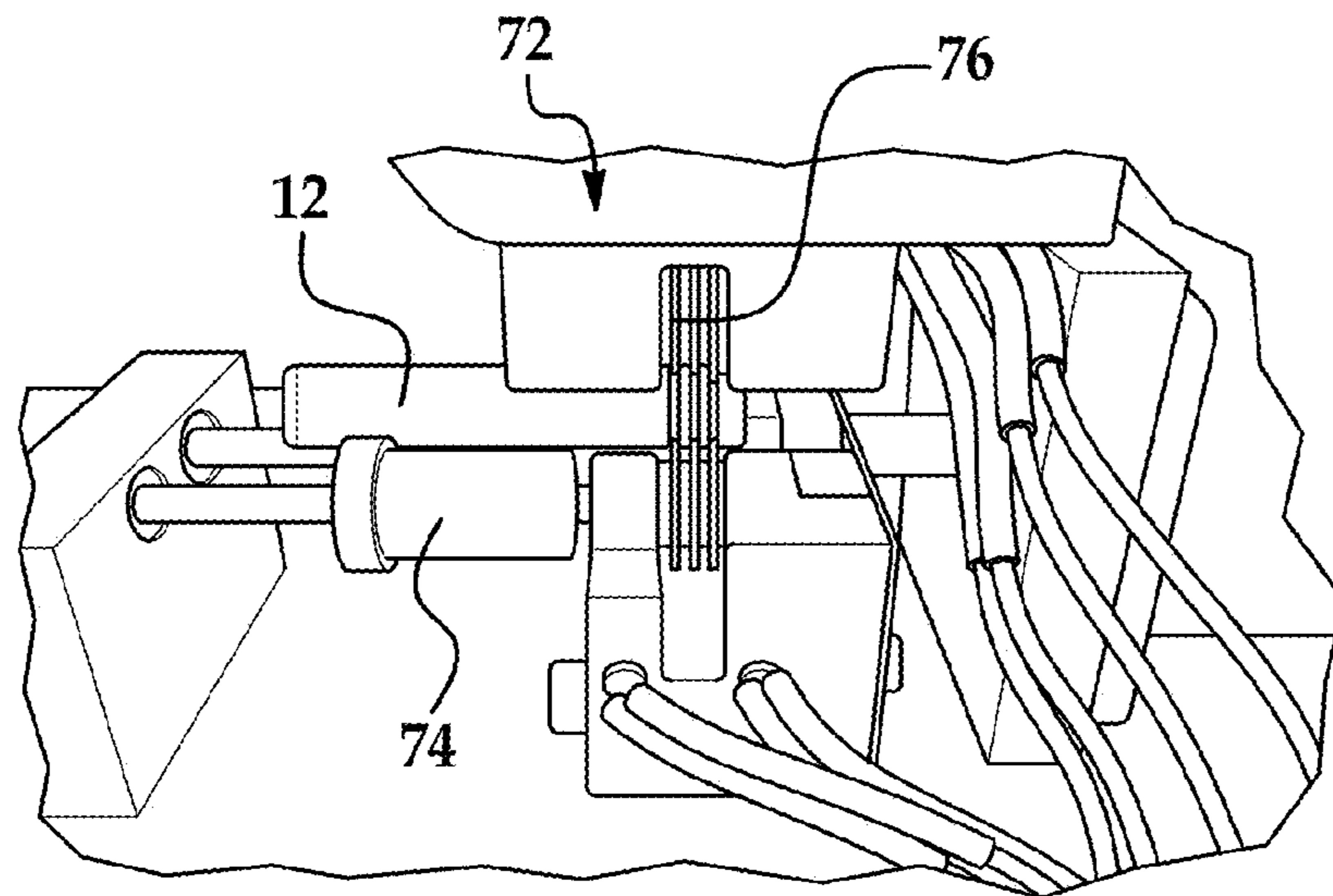


FIG. 12

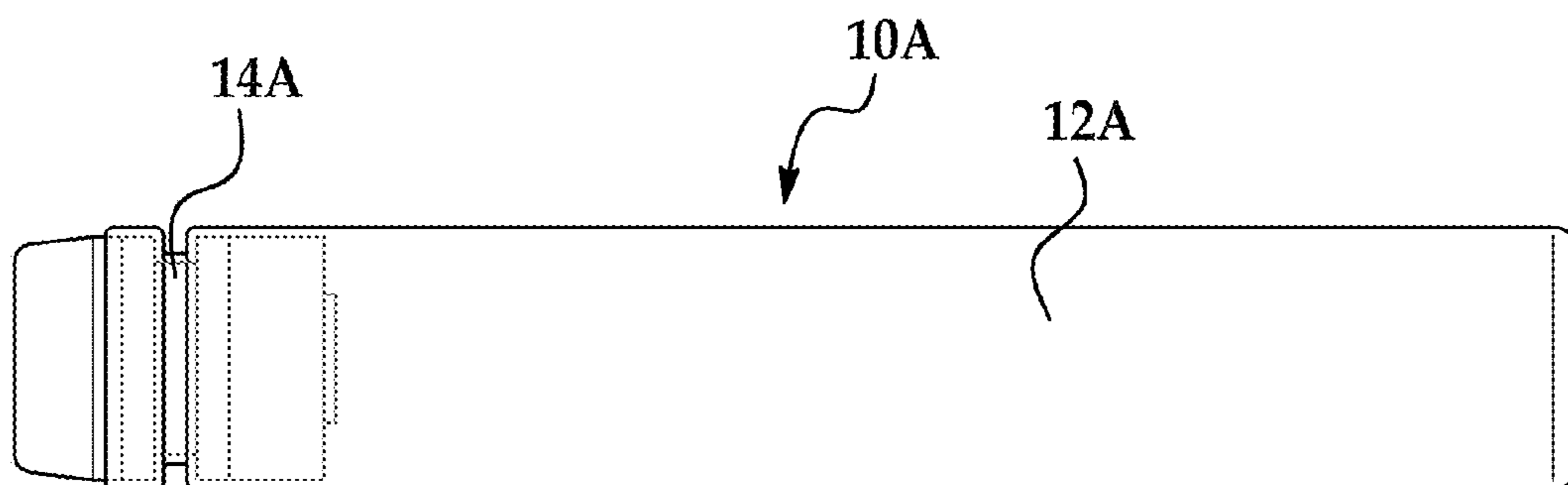


FIG. 13

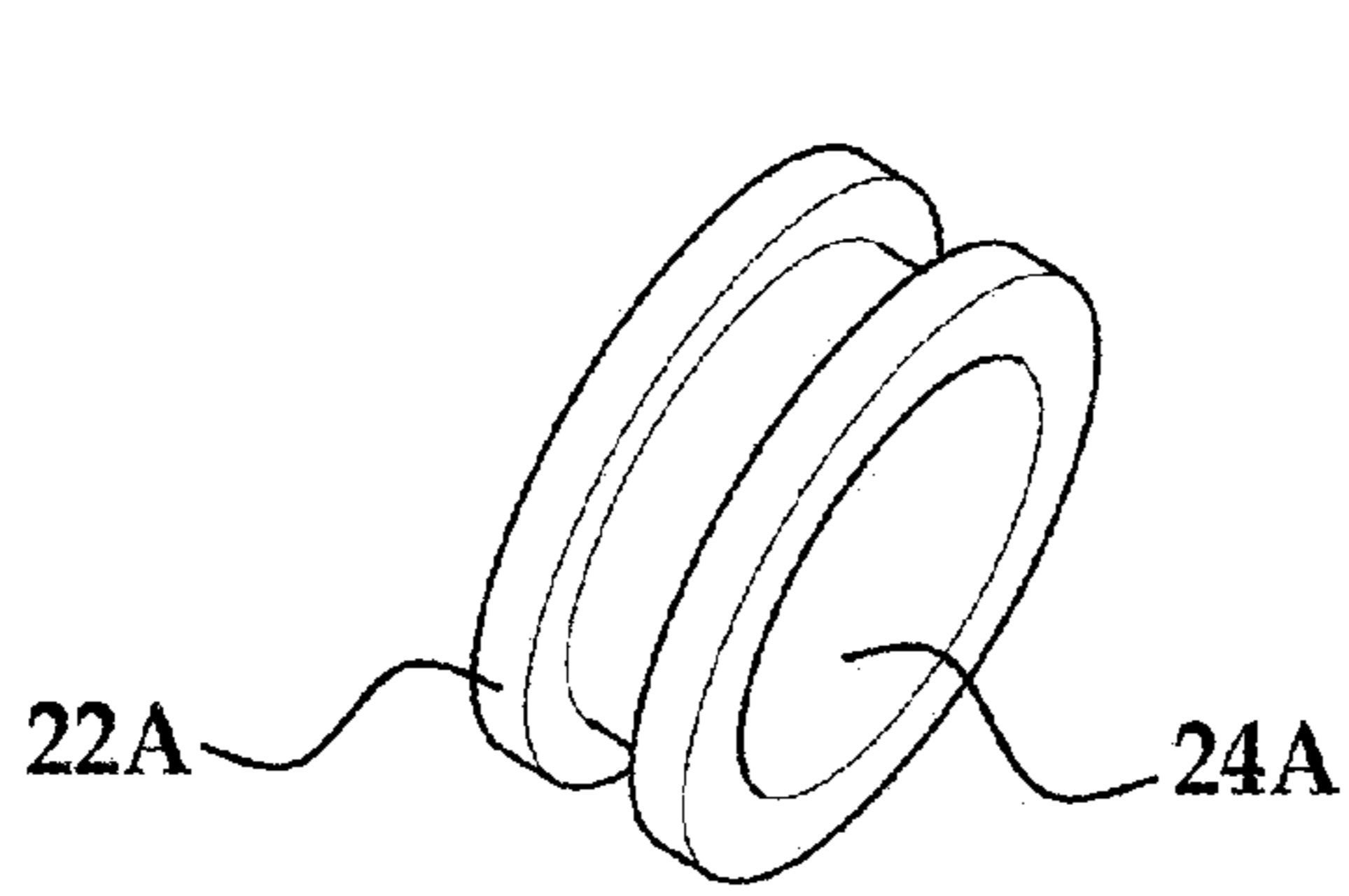


FIG. 13A

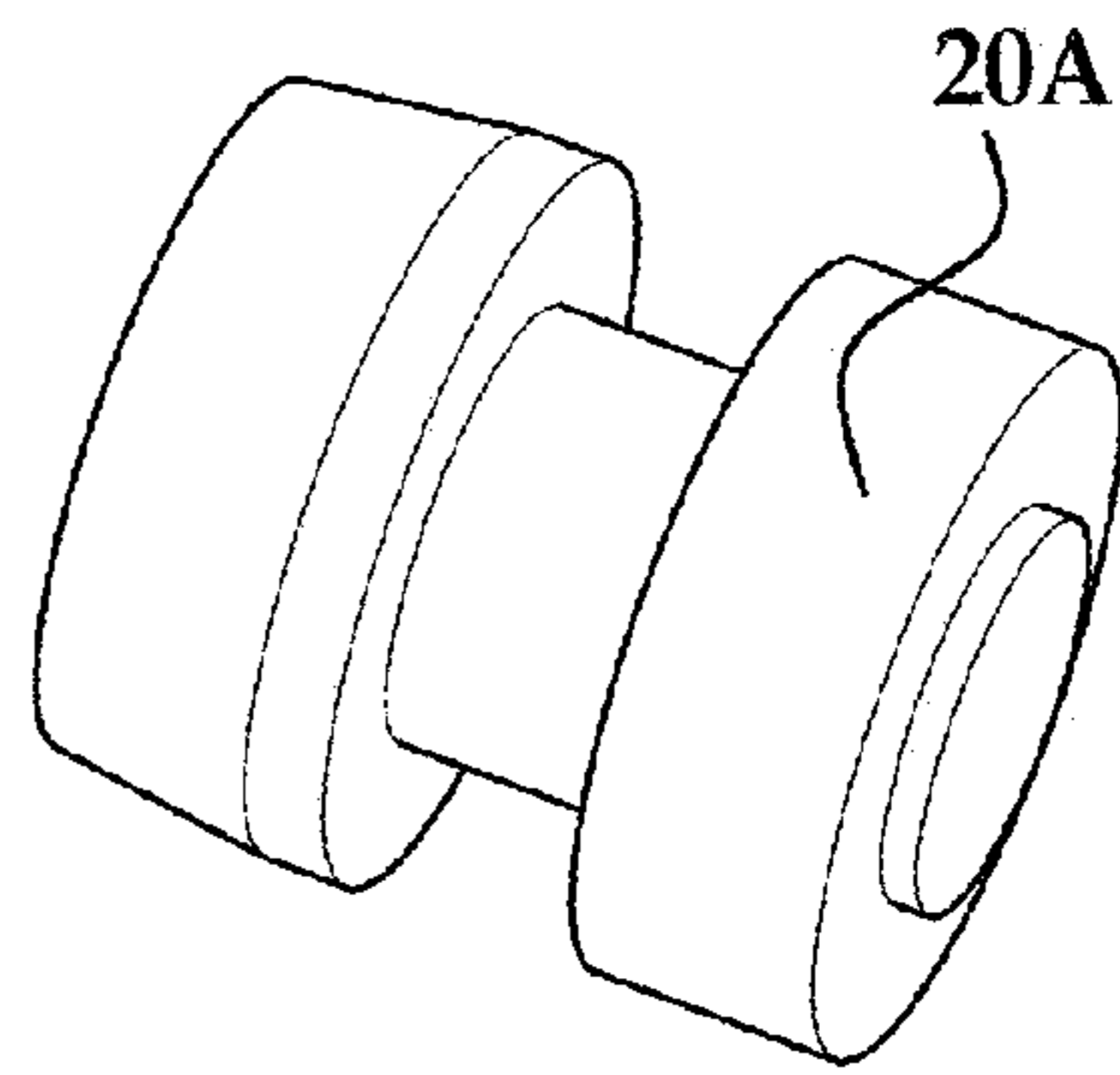


FIG. 13B

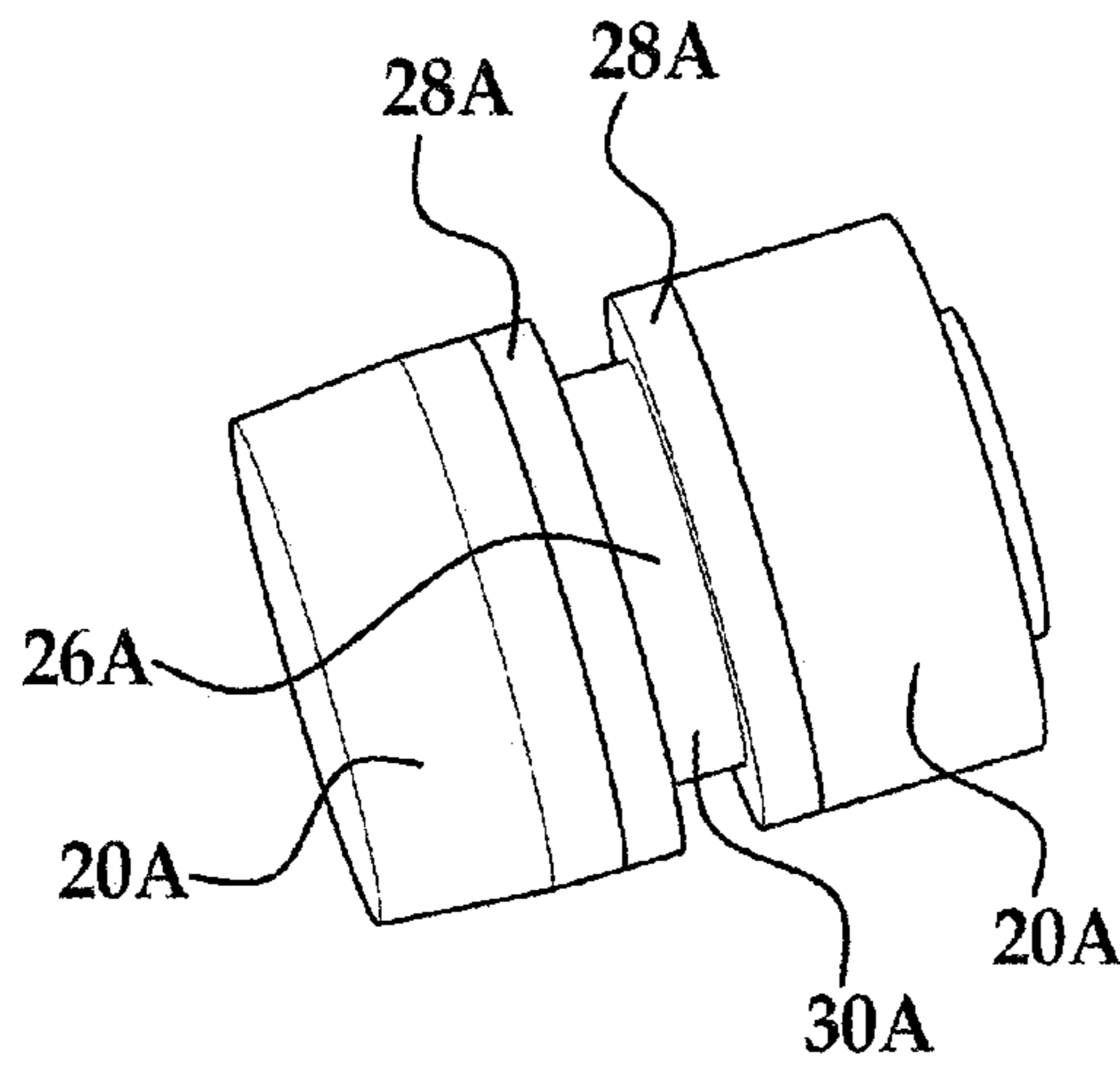


FIG. 13C

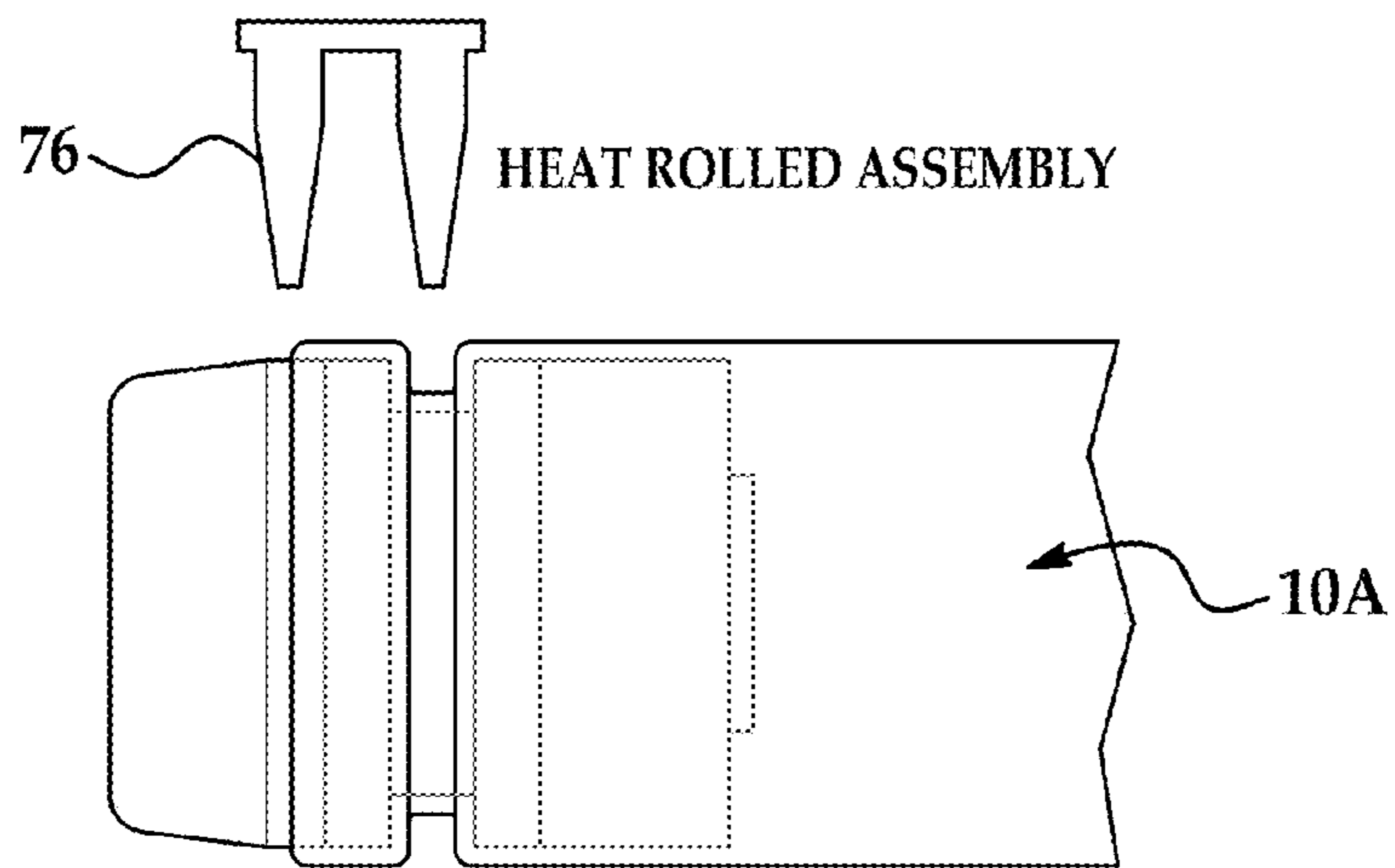


FIG. 13D

1**TOY PROJECTILE AND METHOD OF MAKING****CROSS REFERENCE TO RELATED APPLICATIONS**

This application claims the benefit of U.S. patent application Ser. No. 13/838,900 filed Mar. 15, 2013, the entire contents of which are incorporated herein by reference thereto.

BACKGROUND

Various embodiments of the present invention relate to a toy projectile or dart and a method of making the toy projectile or dart.

Darts or toy projectiles have been used in toy guns or other toys to provide an enhanced play factor to the toy guns or toys. As with any toy projectile, it is desirable to provide the same with a blunt soft end as well as certain characteristics that allow for durability and continued use.

Accordingly, it is desirable to provide a toy dart or toy projectile that is easy to manufacture and have robust characteristics as well as providing for the aforementioned safety features.

SUMMARY OF THE INVENTION

In one embodiment, a toy projectile is provided, the toy projectile having: an elongated dart body secured to a tip assembly, the tip assembly comprising: a tip insert secured to a forward end of the elongated dart body and a tip secured to the tip insert, wherein the tip comprises a styrene ethylene butylene styrene copolymer (SEBS rubber) tip.

In another embodiment, a toy projectile is provided, the toy projectile having: an elongated dart body; a tip assembly, secured to the forward end of the elongated dart body, the tip assembly comprising: a tip insert and a tip portion molded thereto, the tip insert having a plurality of annular features extending from an exterior surface of the tip insert, wherein at least one of the plurality of annular features is covered by the tip portion when the tip portion is molded onto the tip insert and wherein at least one other of the plurality of annular features is only covered by a forward portion of the elongated dart body when it is secured to tip assembly. In one embodiment, the tip portion can be co-molded with the tip insert. In another embodiment, the tip portion can be insert molded with the tip insert.

In yet another embodiment, a method of securing a SEBS rubber tip to an extruded dart body is provided. The method including the steps of: forming a tip assembly by inserting a tip insert into a die of an injection molding machine, wherein the tip insert has a central opening extending therethrough and a plurality of features extending from an exterior surface of the tip insert; insert molding a SEBS rubber material wherein the die of the injection molding machine is configured to allow a portion of the SEBS rubber material to extend into a portion of the central opening and cover some of the plurality of features extending from the exterior surface of the tip insert; removing the tip assembly from the injection molding machine; and securing a forward end of an extruded dart body to at least one of the plurality of features of the tip insert that is not covered by the SEBS rubber material.

In yet another embodiment, a method of securing a SEBS rubber tip to an extruded dart body is provided. The method including the steps of: forming a tip assembly, wherein the

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tip insert has a central opening extending therethrough and a plurality of features extending from an exterior surface of the tip insert; co-molding a SEBS rubber material with the tip insert wherein the SEBS rubber material covers some of the plurality of features extending from the exterior surface of the tip insert; and securing a forward end of an extruded dart body to at least one of the plurality of features of the tip insert that is not covered by the SEBS rubber material.

BRIEF DESCRIPTION OF THE DRAWINGS

These and/or other features, aspects, and advantages of the present invention will become better understood when the following detailed description is read with reference to the accompanying drawings in which like characters represent like parts throughout the drawings, wherein:

FIG. 1 is a view of a dart or projectile in accordance with an exemplary embodiment of the present invention;

FIG. 2 is a cross-sectional view of the dart or projectile along the lines 2-2 of FIG. 1;

FIG. 2A is a cross-sectional view of the dart or projectile along the lines 2A-2A of FIG. 1;

FIG. 2B is an enlarged portion of FIG. 2;

FIGS. 3A and 3B are front and rear perspective views of the dart or projectile illustrated in FIG. 1 in accordance with an exemplary embodiment of the present invention;

FIGS. 4 and 5 are side views of the dart or projectile in accordance with an exemplary embodiment of the present invention;

FIG. 4A is a view along lines 4A-4A of FIG. 4 or a rear view of the dart or projectile of FIG. 1 in accordance with an exemplary embodiment of the present invention;

FIG. 4B is a view along lines 4B-4B of FIG. 4 or a front view of the dart or projectile of FIG. 1 in accordance with an exemplary embodiment of the present invention;

FIG. 6 is a view of a tip assembly constructed in accordance with one non-limiting exemplary embodiment of the present invention;

FIG. 7 is a cross-sectional view of an insert constructed in accordance with one non-limiting exemplary embodiment of the present invention;

FIG. 8 is a cross-sectional view a tip assembly constructed in accordance with one non-limiting exemplary embodiment of the present invention;

FIG. 9 is a flowchart illustrating a method or process for forming a forming a dart or projectile in accordance with one non-limiting exemplary embodiment of the present invention;

FIG. 9A is a flowchart illustrating an alternative method or process for forming a dart or projectile in accordance with another embodiment of the present invention;

FIGS. 10 and 11 illustrate an apparatus for trimming a tail or rearward end of the dart or projectile;

FIG. 12 illustrates an apparatus for securing an extruded dart body to a tip assembly;

FIG. 13 illustrates a dart or projectile formed in accordance with an alternative exemplary embodiment of the present invention; and

FIGS. 13A-13D illustrate portions of the dart or projectile illustrated in FIG. 13.

Although the drawings represent varied embodiments and features of the present invention, the drawings are not necessarily to scale and certain features may be exaggerated in order to illustrate and explain exemplary embodiments the present invention. The exemplification set forth herein illustrates several aspects of the invention, in one form, and such

exemplification is not to be construed as limiting the scope of the invention in any manner.

DETAILED DESCRIPTION

Referring now to the FIGS. and in particular FIGS. 1-5, a dart or projectile **10** constructed in accordance with an exemplary embodiment of the present invention is illustrated. Dart or projectile **10** has an elongated tubular body portion **12** which has a forward end or front end **14** and a rearward or rear end **16**. Rearward or rear end **16** has an opening **17** (see FIG. 2B) that extends into an opening or cavity **19** of the elongated tubular body portion **12**. Referring back to FIG. 1, secured to the forward end **14** is a tip assembly **18**. Tip assembly **18** has a tip portion **20** and a tip insert **22**. The tip portion **20** is secured to a first portion of the tip insert **22** and a second portion of the tip insert **22** is secured to the forward end **14** of the elongated tubular body portion **12**.

Accordingly, tip insert **22** provides a means for securing the tip portion **20** to the forward end **14** of the elongated tubular body portion **12**. In one exemplary embodiment, tip insert **22** is configured to have an inner opening **24** extending therethrough. In addition, an exterior surface **26** of the tip insert **22** is configured to have a plurality of features or annular rings **28** extending away from the exterior surface **26** of the tip insert **22**. In one embodiment, the plurality of features or annular rings **28** provides securement features to which the tip **20** and the forward end **14** are secured thereto. Still further, the plurality of features or annular rings also provide a plurality of grooves **30** located between the annular rings. The features or annular rings **28** as well as the grooves **30** located therebetween provide a mechanism for rigidly securing the forward end **14** to the tip assembly **18**. In one implementation and as the material of forward end **14** is pushed between annular rings **28** and then cooled, an interlock of the tip assembly **18** and the tubular body portion **12** is formed.

FIG. 6 illustrates a tip assembly **18** formed in accordance with one non-limiting exemplary embodiment of the present invention. FIG. 7 is a cross-sectional view of the tip insert **22** formed in accordance with one non-limiting exemplary embodiment of the present invention while FIG. 8 is a cross-sectional view of the tip insert **22** with the tip **20** secured thereto. As illustrated, the plurality of features or annular rings **28** provides securement features to which the tip **20** and the forward end **14** are secured thereto. Still further, the plurality of features or annular rings **28** also provide a plurality of grooves **30** located between the annular rings. In accordance with one embodiment, the height or distance of the annular rings **28** may vary. In addition, a rearward end **32** of the tip insert **22** may be formed with a flange portion **34** which provides additional rigidity to the tip insert and/or tip assembly and in particular to the area that is secured to the forward end **14** of the elongated dart body **12**.

In accordance with one non-limiting exemplary embodiment, the tip insert **22** is formed from the following material TPR Thermoflex ME1385 via an injection molding process. Of course, other equivalent materials for forming the tip insert are considered to be within the scope of exemplary embodiments of the present invention. In one non-limiting exemplary embodiment, the core part or tip insert **22**, was shot at a temp of 225° C. and the shot pressure was 65 bar for a cycle time of 40 seconds. Of course, other temperatures, times and pressures greater and less than the afore-

mentioned values are considered to be within the scope of various embodiments of the present invention.

In accordance with one non-limiting exemplary embodiment, the tip **20** is formed from a styrene ethylene butylene styrene copolymer (SEBS rubber) or more particularly the following material TPR Thermoflex ME1927 via an injection molding process. Of course, other equivalent materials for forming the tip are considered to be within the scope of exemplary embodiments of the present invention. In one non-limiting exemplary embodiment, the tip part was shot at a temp of 225° C. and the shot pressure was 50 bar for a cycle time of 60 seconds. Of course, other temperatures, times and pressures greater and less than the aforementioned values are considered to be within the scope of various embodiments of the present invention.

In accordance with one non-limiting exemplary embodiment, the elongated tubular body portion **12** is formed from an extrusion process wherein the tubular body portion is formed from a polyethylene which in one embodiment comprises 60% LDPE and 40% HDPE. Of course, other equivalent materials and combinations thereof are considered to be within the scope of exemplary embodiments of the present invention.

Referring now to FIG. 9, a flowchart **40** illustrating one non-limiting method for forming the dart or projectiles **10** is provided. At box **42** at least one or a plurality of tip inserts **22** are formed by the aforementioned injection molding process. Simultaneously, previously or afterwards at least one or a plurality of elongated tubular dart body portion **12** are formed by an extrusion process at step **44**. During this step or process the tubular body portion **12** is formed from an extrusion machine wherein an elongated member is extruded from the aforementioned materials and once cooled, the extruded member is cut into the desired lengths for use as tubular body portion **12**.

At step **46**, the rear end or tail end **16** of the elongated tubular dart body portion proximate to opening **17** is trimmed to have a curved or rounded surface **48** (see at least FIG. 1). Once trimmed, the elongated tubular body portion **12** is ready to be secured to the tip assembly **18**. In an alternative embodiment step **46** may be eliminated.

At a step **50**, the molded tip insert **22** is inserted into an injection molding machine wherein the tip portion **20** is insert molded onto a portion of the tip insert **22** as described above and illustrated in the attached FIGS. Once this process is complete, the tip assembly **18** is now formed.

After conclusion of the process at step **50**, the form tip assemblies **18** are now secured to the elongated body portions **12** via a heat treating process which occurs at step **52**.

Referring to FIG. 9A, a flowchart illustrating another method **100** for forming a dart or projectile according to the present invention is illustrated. As shown, the method **100** includes several steps that are performed. In step **102**, the tip insert for the dart is injection molded. Subsequently, in step **104**, a SEBS tip for the dart is co-molded with the tip insert. In one implementation of this process, the mold in which the tip insert is injection molded is rotated to reposition it so that the SEBS material can be inserted into the mold to be co-molded with the tip insert. In one exemplary process, the mold is rotated 180 degrees between step **102** and step **104**.

In step **106**, the body of the dart is formed. In this process, the dart body is extruded in a substantially cylindrical form with an opening or channel therethrough. In step **108**, the extruded body of the dart is cut by a machine in an automated process. The dart body has a desired length and any excess material beyond that length is trimmed. In step

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110, the end 17 of the dart body is rolled to form a slightly curved or curled end as shown in the drawings.

In step 112, the tip insert is engaged with the dart body. In particular, the tip insert has a first end to which SEBS material has been co-molded and a second end opposite the first end. The second end of the tip insert is inserted into an open end of the dart body. The tip insert is inserted so that a few of the grooves on the tip insert are located inside the dart body. In step 114, the dart body is coupled to the tip insert via a heat rolling process. In this process, heat and pressure are applied to the dart body via a tool, such as a pair of rollers, that is aligned with some of the grooves of the tip insert. The dart body is rotated about its longitudinal axis so that the tool remains in contact with the dart body as it rotates, thereby causing the dart body to conform to the profile of the tip insert and be pushed into the grooves of the tip insert. When the dart body has been coupled to the tip insert via this process, the forming of the dart is complete.

Referring now to FIGS. 10 and 11, apparatus for use in one embodiment of a dart body forming process according to the invention are illustrated. As shown, an apparatus 54 for use in the trimming step 46 is illustrated. Apparatus 54 has a plunger 56 onto which the extruded elongated body 12 is placed and an end portion 58 of plunger 56 has corresponding rounded ends which form the rounded ends or end 48 of the elongated body portion 12 when plunger 56 is moved towards a copper plate or other of material 70 which is heated in order to manipulate or trim the extruded elongated body 12 to have a trimmed end or rounded surface 48.

FIG. 12 illustrates an apparatus 72 for use in step 52 wherein the elongated body 12 with the tip insert inserted into a forward end 14 of the elongated body 12 is placed between a pair of rollers 74 which rotate the same. A heated copper roller assembly or other equivalent material 76 applies heat and pressure to the forward end 14 of the elongated body such that portions of the same are now pushed into the grooves 30 of tip insert 22 so that the elongated body 12 is now secured to the tip assembly 18 and the dart or projectile 10 is formed.

Referring now to the FIGS. 13-13D an alternative exemplary embodiment of the present invention is illustrated. Here the tip insert 22A and the tip portion 20A have alternative configurations. In this embodiment, after the insert molding process the tip 20A or material used to form tip 20A extends completely through the central opening 24A of the tip insert 22A and is received within the central opening of the elongated tubular body 12A. In addition and in this embodiment, the forward end 14A of the elongated body 12A is formed onto features 28A and groove 30A as well as a portion of tip portion 20A. Of course, numerous other configurations are considered to be within the scope of exemplary embodiments of the present invention and the above embodiments are merely examples of various embodiments of the present invention.

As discussed above, the insert molding process of forming the tip and the tip insert is only one process used in the forming of a dart according to the present invention. A dart may be formed using the injection molding and co-molding processes described above as well. The heat rolling process is used to couple the tip insert to the dart body as described above as well.

As used herein, the terms "first," "second," and the like, herein do not denote any order, quantity, or importance, but rather are used to distinguish one element from another, and the terms "a" and "an" herein do not denote a limitation of quantity, but rather denote the presence of at least one of the referenced item. In addition, it is noted that the terms

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"bottom" and "top" are used herein, unless otherwise noted, merely for convenience of description, and are not limited to any one position or spatial orientation.

The modifier "about" used in connection with a quantity is inclusive of the stated value and has the meaning dictated by the context (e.g., includes the degree of error associated with measurement of the particular quantity).

While the invention has been described with reference to an exemplary embodiment, it will be understood by those skilled in the art that various changes may be made and equivalents may be substituted for elements thereof without departing from the scope of the invention. In addition, many modifications may be made to adapt a particular situation or material to the teachings of the invention without departing from the essential scope thereof. Therefore, it is intended that the invention not be limited to the particular embodiment disclosed as the best mode contemplated for carrying out this invention, but that the invention will include all embodiments falling within the scope of the appended claims.

What is claimed is:

1. A method of securing a styrene ethylene butylene styrene copolymer (SEBS) tip to an extruded dart body, comprising:

forming a tip assembly by inserting a tip insert into a die of an injection molding machine, wherein the tip insert has a central opening extending therethrough and a plurality of individual features extending from an exterior surface of the tip insert;

insert molding a SEBS material wherein the die of the injection molding machine is configured to allow a portion of the SEBS material to extend into a portion of the central opening and cover some of the plurality of features extending from the exterior surface of the tip insert;

removing the tip assembly from the injection molding machine; and

securing a forward end of the extruded dart body to at least one of the plurality of individual features of the tip insert that is not covered by the SEBS material.

2. The method as in claim 1, wherein the forward end of the extruded dart body is secured to the tip insert by a heat treating process.

3. The method as in claim 1, wherein a portion of the forward end of the extruded dart body secured to the tip assembly is received within a groove located between at least two of the plurality of individual features of the tip insert that are not covered by the SEBS material.

4. The method as in claim 1, wherein the plurality of individual features extend outwardly from the exterior surface of the tip insert.

5. The method as in claim 1, further comprising: cutting to length the extruded dart body.

6. The method as in claim 5, further comprising: trimming a rearward end of the extruded dart body to form a curved or rounded end.

7. The method as in claim 2, wherein the heat treating process includes a heat rolling process that rotates the body of the dart.

8. A method of securing a styrene ethylene butylene styrene copolymer (SEBS) tip to an extruded dart body, comprising:

forming a tip assembly by:

injection molding a tip insert, wherein the tip insert has a central opening and a plurality of individual features extending from an exterior surface of the tip insert;

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co-molding a SEBS material with the tip insert, wherein a portion of the SEBS material extends into a portion of the central opening and covers some of the plurality of individual features extending from the exterior surface of the tip insert;

extruding a body of the dart; and

coupling the body of the dart to the tip insert via a heat treating process.

9. The method as in claim 8, wherein the coupling the body of the dart to the tip insert includes securing a forward end of the extruded dart body to at least one of the plurality of individual features of the tip insert that is not covered by the SEBS material.

10. The method as in claim 8, wherein the heat treating process includes a heat rolling process that rotates the body of the dart.

11. The method as in claim 8, further comprising: cutting to length the body of the dart.

12. The method as in claim 11, further comprising: trimming a rearward end of the body of the dart to form a curved or rounded end.

13. The method as in claim 8, wherein the plurality of individual features extend outwardly from the exterior surface of the tip insert.

14. The method as in claim 13, wherein the coupling the body of the dart to the tip insert includes securing a forward end of the extruded dart body to a groove located between at least two of the plurality of outwardly extending individual features of the tip insert that are not covered by the SEBS material.

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15. A method of securing a styrene ethylene butylene styrene copolymer (SEBS) tip to a dart body, comprising: forming a tip assembly by:

molding a tip insert, wherein the tip insert has a central opening and a plurality of individual features extending from an exterior surface of the tip insert;

molding a SEBS material with the tip insert, wherein a portion of the SEBS material extends into a portion of the central opening and covers some of the plurality of individual features extending from the exterior surface of the tip insert;

forming a body of the dart; and

coupling the body of the dart to the tip insert.

16. The method as in claim 15, wherein the body of the dart is formed by extrusion.

17. The method as in claim 15, wherein the molding of the tip insert is injection molding.

18. The method as in claim 15, wherein the molding the SEBS material with the tip insert is co-molding.

19. The method as in claim 15, wherein the coupling the body of the dart to the tip insert comprises a heat treating process.

20. The method as in claim 15, wherein the plurality of individual features extend outwardly from the exterior surface of the tip insert, and wherein the coupling the body of the dart to the tip insert includes securing a forward end of the dart body to a groove located between at least two of the plurality of outwardly extending individual features of the tip insert that are not covered by the SEBS material.

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